









Work Order ID 56844

March 10, 2010 3:53:24 PM

Page 1

Item ID: D3805-043 Accept  Setup Start 
Revision ID:  Stop 
Item Name: Wearplate Assembly Fwd, High Gear
Start Date: 10/03/2010 Start Qty: ~~2.00~~ 5  Cust Item ID:
Required Date: 17/03/2010 Req'd Qty: 2.00  Customer:
Reference:

Approvals: Process Plan: 14 Date: 10-3-10 Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3805	Rev A								

100



Large Fab

Large Fab

0.00

Memo

0.00

1- on D3806-3, fill cut outs with hardcoat welding rod as per dwg D3805
2059 B Hardcoat Welding Rod
BATCH#: M 114373

2-weld D3806-3 to wearplate by positioning holes together as per dwg D3805
304 S.S. Welding Rod
BATCH #: M 102421

3-Transfer drill holes in bar

FL 10-4-29 X5

110



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

5 PD 10.0505

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Work Order ID 56844

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Page 3

Item ID: D3805-043

Accept



Setup Start



Revision ID:

Item Name: Wearplate Assembly Fwd, High Gear

Stop



Start Date: 10/03/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 17/03/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150		0.00							
	Small Fab								
	Memo	0.00							
	Small Fab								
	1- Bond D3807-3 gasket to inner surface of wearplate using a thin layer of 3m 1300/1300L scotch grip adhesive as per dwg BATCH: <u>M113174</u>								
160	QC5- Inspect part completeness to step on W/O	0.00							
	QC								
	Memo	0.00							
	Quality Control								
170	Identify as per dwg & Stock Location: <u>P00</u>	0.00							
	Packaging								
	Memo	0.00							
	Packaging								

4/5/10/05/10 (S)

(S)

Accept (S)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Work Order ID 56844

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Page 4

Item ID: D3805-043

Accept



Setup Start



Revision ID:

Item Name: Wearplate Assembly Fwd, High Gear

Stop



Start Date: 10/03/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 17/03/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/10 *[Signature]*

MF 10-5-10

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NOTE: Date & initial all entries

Picklist Print

March 10, 2010 3:53:29 PM

Page 1

Work Order ID: 56844

Parent Item: D3805-043

Parent Item Name: Wearplate Assembly Fwd, High Gear


Comments: IPP RevB: add transfer drill wearplate to bar DD 09.11.05 verified by:EC

Start Date: 10/03/2010

Required Date: 17/03/2010


Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3805-3  Plate		Manufactured	No			100	Each	1.0000	2.0000			


* P 56863 x4
B 52853 x1

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	1	
46930	1	

D3806-3  Bar		Manufactured	No			100	Each	0.0000	2.0000			
---	--	--------------	----	--	--	-----	------	--------	--------	--	--	--

56864 x4 52852 x1

EL 10-4-28

D3807-3  Gasket		Manufactured	No			150	Each	2.0000	2.0000			
---	--	--------------	----	--	--	-----	------	--------	--------	--	--	--

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST236B	2	
52836		

B 56865 (3x)²

2

10/05/10

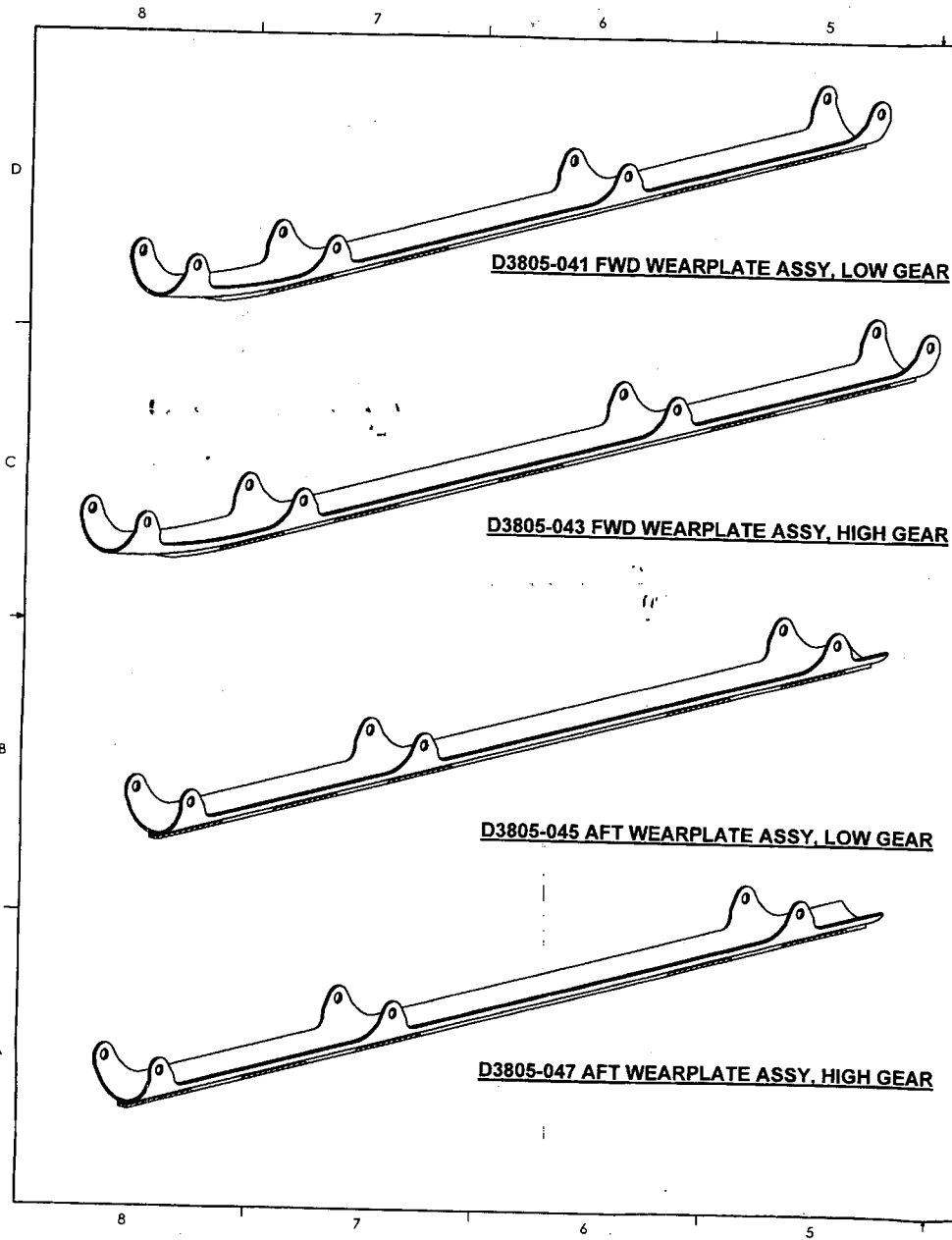
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ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
1	X				D3805-041	FWD WEARPLATE ASSY, LOW GEAR
2		X			D3805-043	FWD WEARPLATE ASSY, HIGH GEAR
3			X		D3805-045	AFT WEARPLATE ASSY, LOW GEAR
4				X	D3805-047	AFT WEARPLATE ASSY, HIGH GEAR
11	1				D3805-1	PLATE
12		1			D3805-3	PLATE
13			1		D3805-5	PLATE
14				1	D3805-7	PLATE
15	1				D3806-1	BAR
16		1			D3806-3	BAR
17			1		D3806-5	BAR
18				1	D3806-7	BAR
19	1				D3807-1	GASKET
20		1			D3807-3	GASKET
21			1		D3807-5	GASKET
22				1	D3807-7	GASKET
31	A/R	A/R	A/R	A/R	2059B	HARDCOAT
32	A/R	A/R	A/R	A/R	1300 (OR 1300L)	3M SCOTCH-GRIP ADHESIVE

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED CO
 SUBJECT TO AMENDMEN
 WITHOUT NOTICE
 WORK ORDER
 NO. 56844
B/H-3-10

RELEASED
 09-03-07
 Pw ECN 09-338

A	NEW ISSUE	MB	08.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	DART AEROSPACE USA, INC. PORT HADLOCK, WA DRAWING NO. D3805 TITLE WEARPLATE ASSY SCALE NTS	REV. A	
DRAWN		SHEET 1 OF 8	
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.11.21		

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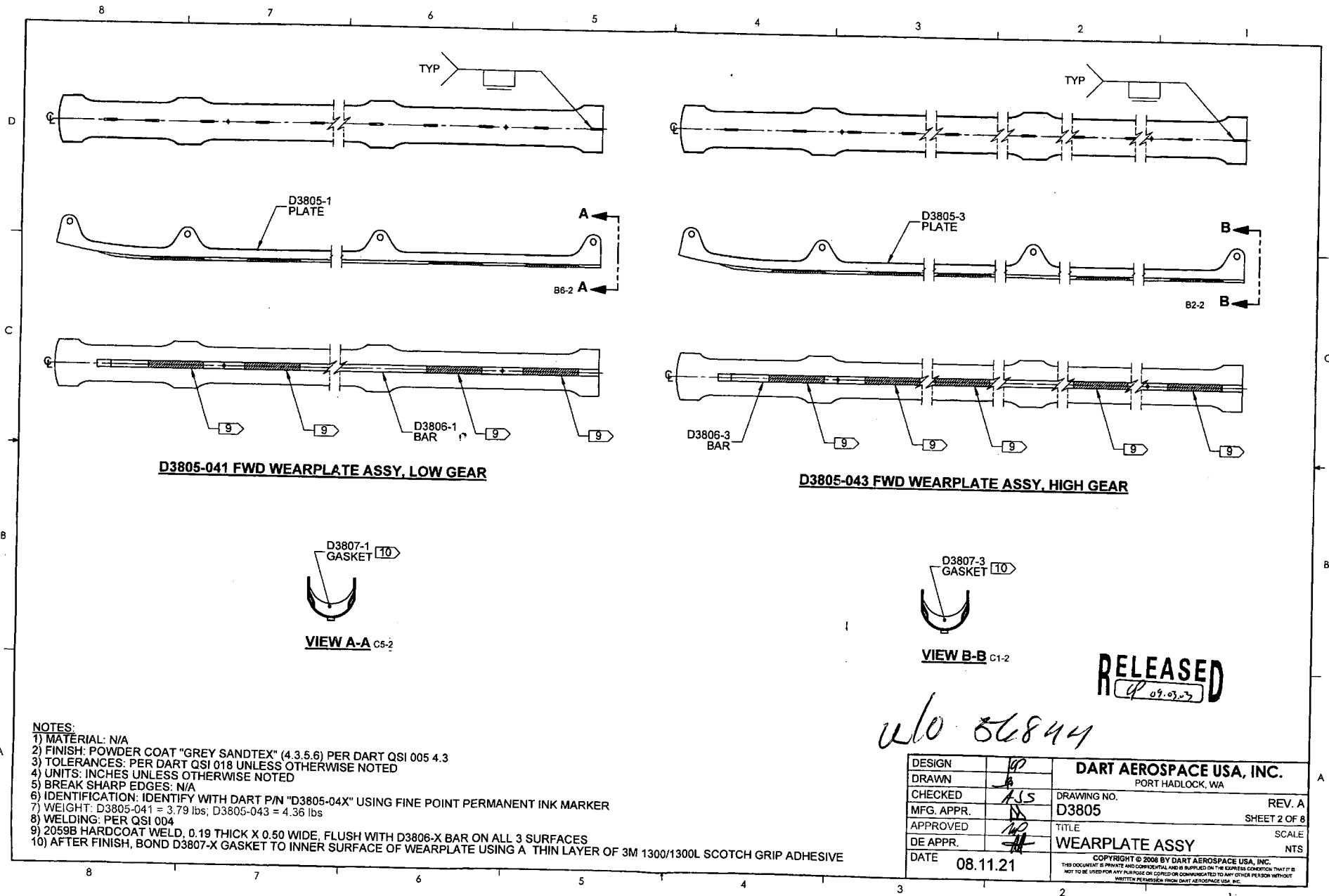
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
09.03.03

DESIGN	10	DART AEROSPACE USA, INC.	
DRAWN	10	PORT HADLOCK, WA	
CHECKED	115	DRAWING NO.	REV. A
MFG. APPR.	11	D3805	SHEET 2 OF 8
APPROVED	11	TITLE	SCALE
DE APPR.	11	WEARPLATE ASSY	NTS
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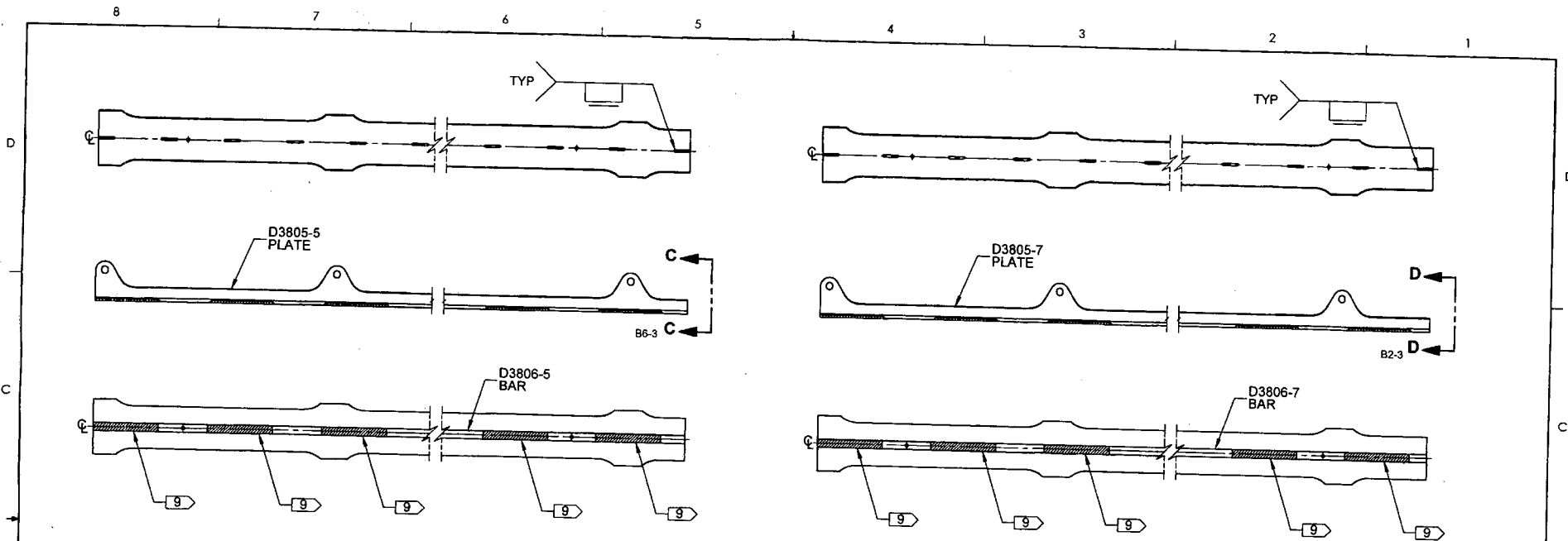
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

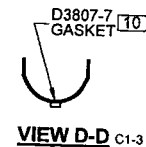
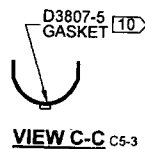
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NOTE: Date & initial all entries



D3805-045 AFT WEARPLATE ASSY.

D3805-047 AFT WEARPLATE ASSY.



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3805-045 = 3.93 lbs; D3805-047 = 4.21 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D3806-X BAR ON ALL 3 SURFACES
- 10) AFTER FINISH, BOND D3807-X GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

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CHECKED	15	DRAWING NO.	REV. A
MFG. APPR.	15	D3805	SHEET 3 OF 8
APPROVED	15	TITLE	SCALE
DE APPR.	15	WEARPLATE ASSY	NTS
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09.03.07

WLO 56844

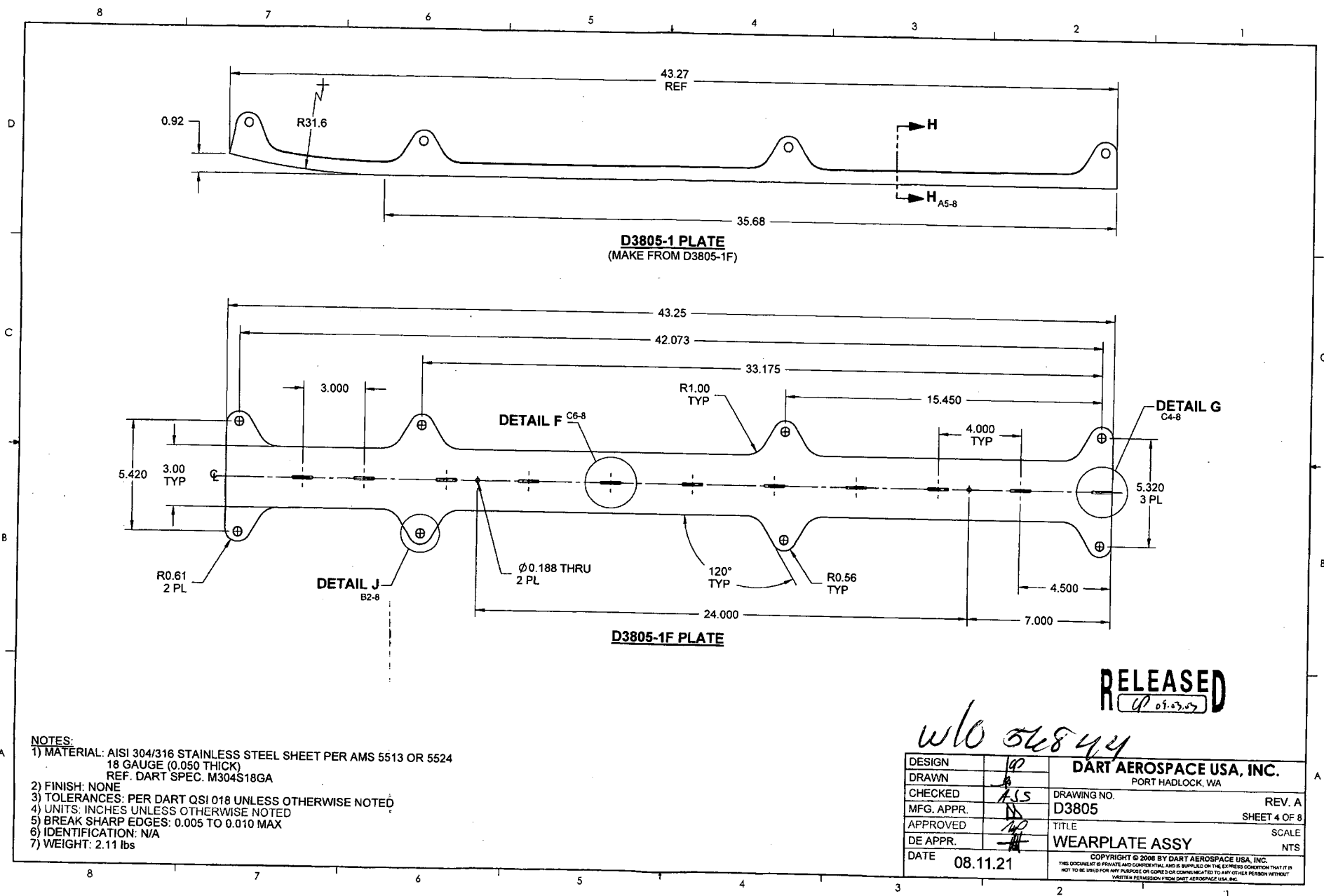
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
09.03.03

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.11 lbs

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CHECKED	155	DRAWING NO.	REV. A
MFG. APPR.	155	D3805	SHEET 4 OF 8
APPROVED	155	TITLE	SCALE
DE APPR.	155	WEARPLATE ASSY	NTS
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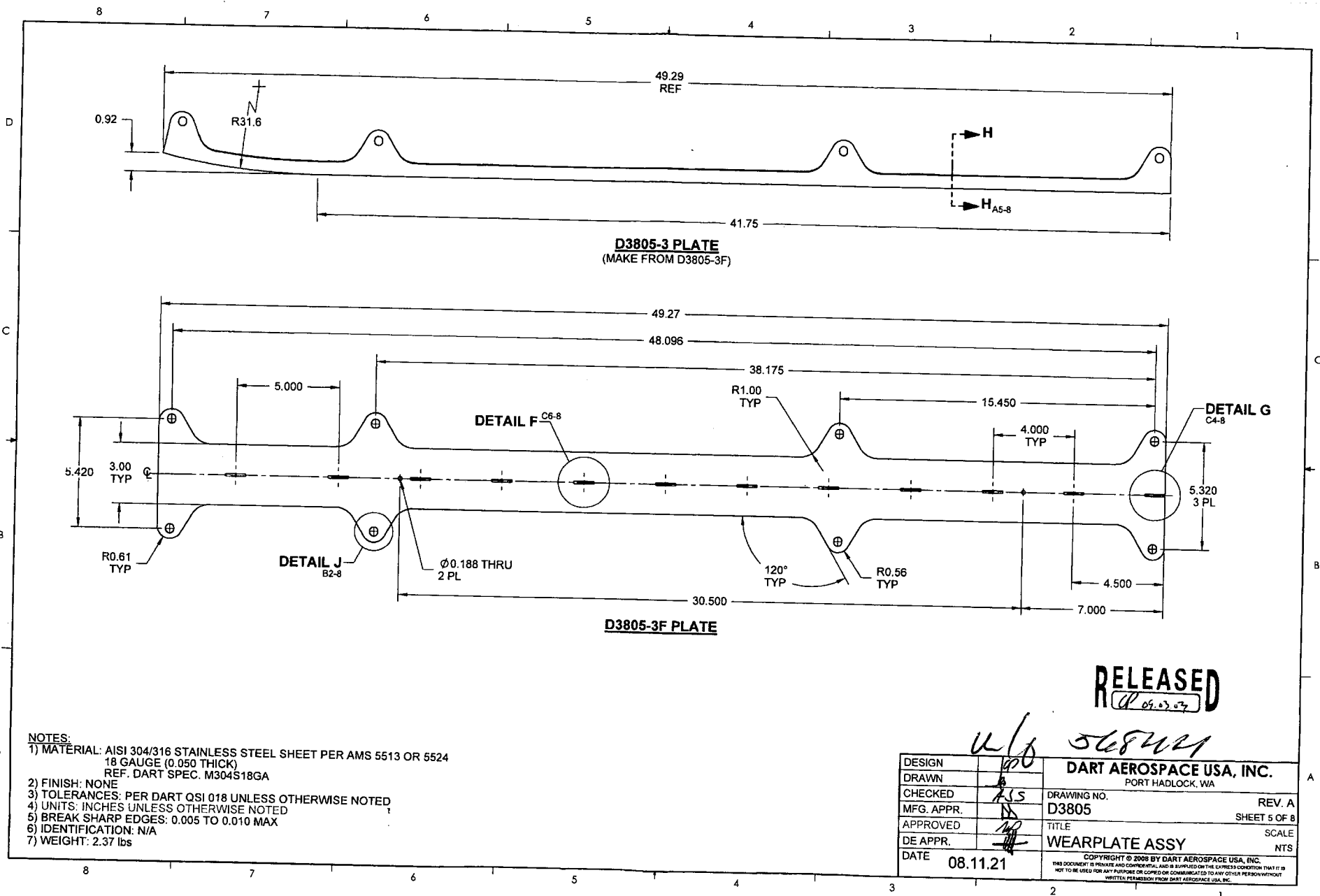
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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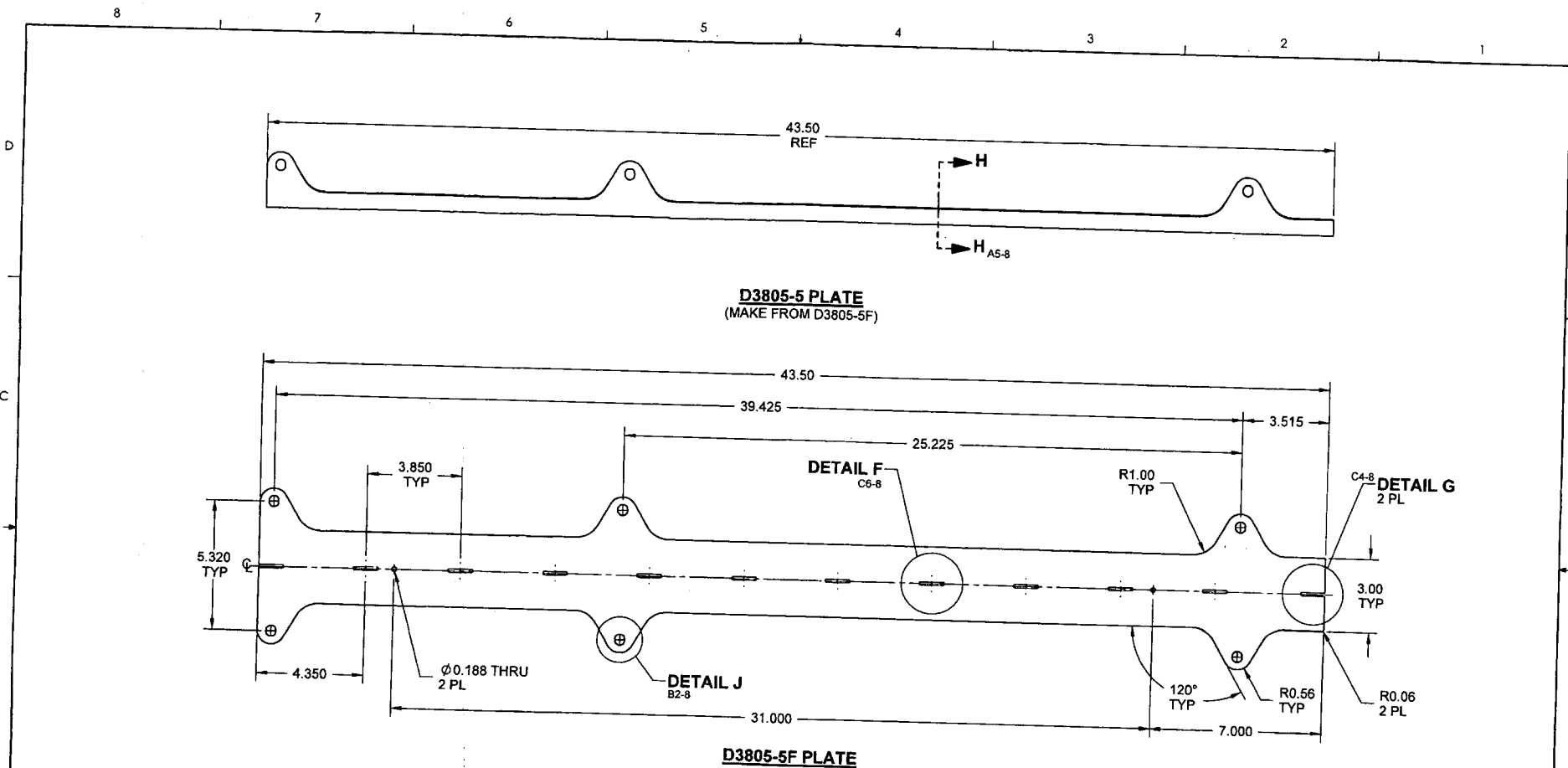
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18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.06 lbs

RELEASED
09-03-03

DESIGN	WLO 56844	DATE	08.11.21
DRAWN	WLO	DESIGN NO.	D3805
CHECKED	WLO	TITLE	WEARPLATE ASSY
MFG. APPR.	WLO	SCALE	NTS
APPROVED	WLO	REV. A	SHEET 6 OF 8
DE APPR.	WLO	DATE	08.11.21
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PORT HADLOCK, WA

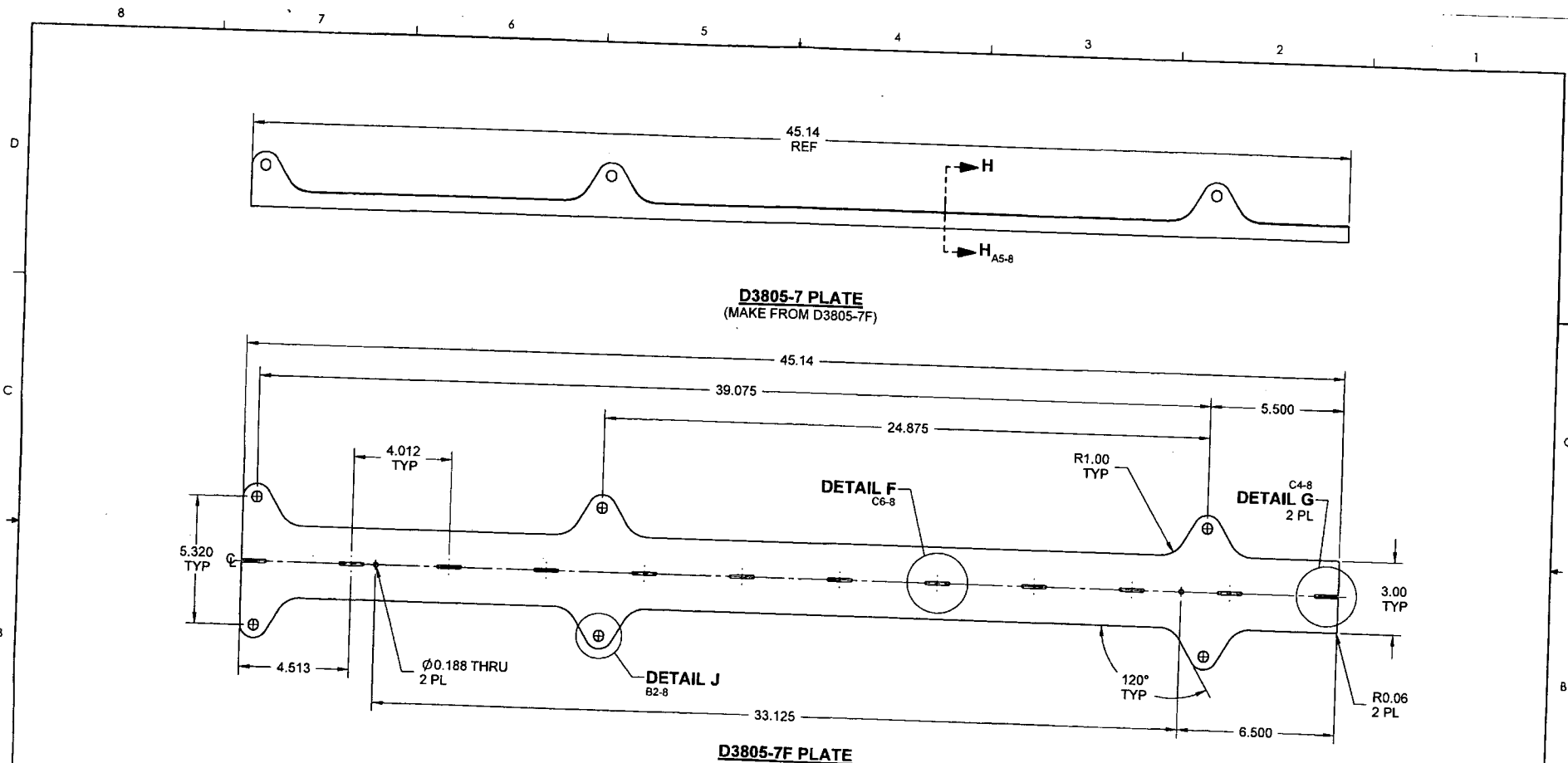
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04.03.07

- NOTES:
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REF. DART SPEC. M304S18GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 2.13 lbs

DESIGN	JP	DART AEROSPACE USA, INC.	REV. A
DRAWN	JP	PORT HADLOCK, WA	SHEET 7 OF 8
CHECKED	LS	DRAWING NO. D3805	SCALE NTS
MFG. APPR.	LS	TITLE WEARPLATE ASSY	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC.
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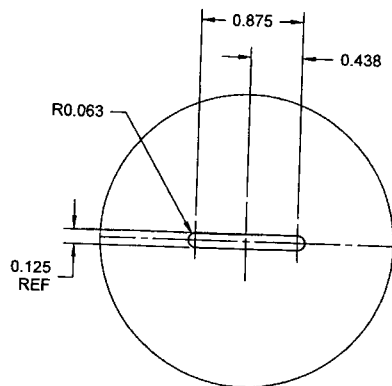
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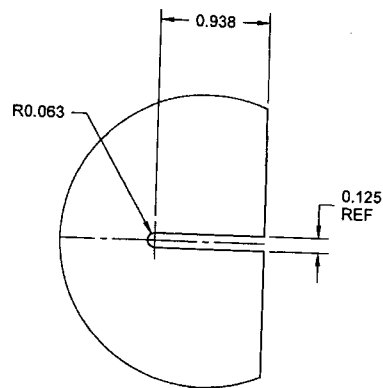
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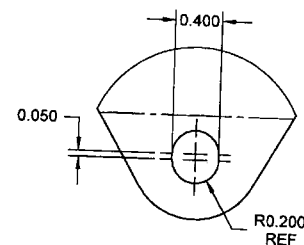
DETAIL F
SLOT DETAIL TYP
SCALE 4X

C5-4
C5-5
C4-6
C4-7



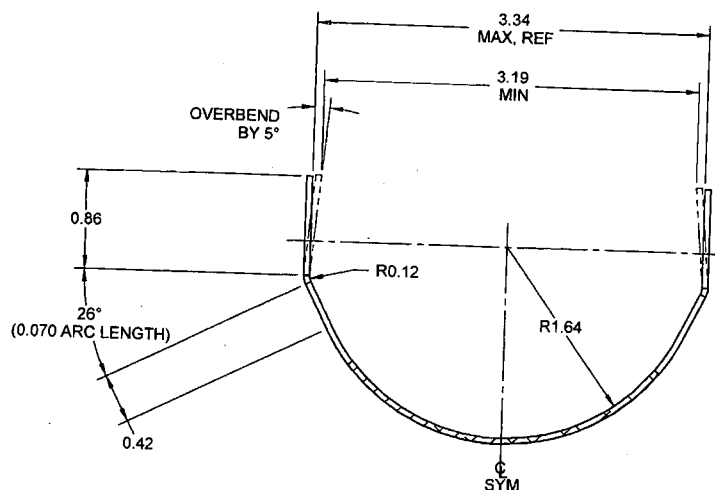
DETAIL G
SLOT DETAIL TYP
SCALE 4X

C1-4
C1-5
C1-6
C2-7



DETAIL J
SCALE 4X

B6-4
B7-5
B5-6
B5-7



SECTION H-H
SCALE 4X

D3-4
D3-5
D3-6
D3-7

RELEASED
4709.53.53

W/O 56844

DESIGN	147	DART AEROSPACE USA, INC.	
DRAWN	147	PORT HADLOCK, WA	
CHECKED	147	DRAWING NO.	REV. A
MFG. APPR.	147	D3805	SHEET 8 OF 8
APPROVED	147	TITLE	SCALE
DE APPR.	147	WEARPLATE ASSY	NTS
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